

Split-2

Work Order ID 66698

Thursday, February 24, 2011 9:45:37 AM

Page 1

Item ID: D2893-1

Revision ID:

Item Name: 2.75 Support

Start Date: 3/25/2011 Start Qty: 20.00

Required Date: 3/25/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: *MC*

Date: 11-02-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2893

Rev B

100

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA081 Tumble & Deburr

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Run Start

Stop

*20 19**20 19**20 19*

Work Order ID 66698

Thursday, February 24, 2011 9:45:37 AM

Page 2

Item ID: D2893-1

Accept

Revision ID:

Item Name: 2.75 Support

Start Date: 3/25/2011 Start Qty: 20.00

Required Date: 3/25/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo
M 11595L

Memo

0.00

Mask Inside Bore for Priming START TIME:
0:45 OVEN TEMPERATURE: 400° FINISH
TIME: 9:15

2019 BL 11-3-09

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

2019 d M 11/03/09

150

SprayPaint

0.00



SprayPaint

Spray Painting

Memo

0.00

Prime inside surface as per Dwg D2893 and QSI 005 4.3

FT 11-03-2019 (19)

Work Order ID 66698

Thursday, February 24, 2011 9:45:37 AM



Page 3

Item ID: D2893-1

Accept



Setup Start



Revision ID:

Item Name: 2.75 Support

Stop



Start Date: 3/25/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Sulos/29

4/19

*rtube
assy*

25 11-03-29 x 19

4/03/29

*MF
11-03-29*

Picklist Print

Page 1

Thursday, February 24, 2011 9:45:45 AM

Work Order ID: 66698



Parent Item: D2893-1



Parent Item Name: 2.75 Support

Start Date: 3/25/2011

Required Date: 3/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C 02.11.26 Reformat: Added P/O KJ
 IPP D 06.04.19 removed alodine EC
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM
 IPP F 08.03.19 Re-format EC verified by: DD
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	20.0000	0.5	10			


 D2893-1 TURNING DETAIL



Location

Loc Qty

Loc Code

MAT

20

64897

10

66248

10

10 *ml 4/03/01*

DART AEROSPACE LTD		Work Order:	011698
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997	2.998	2.997	2.998	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.130	.130	.130	.130	.130
AD	0.040	0.060		.057	.057	.050	.050	.057
AE	0.188	0.193		.089	.190	.190	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.154	.149	.148	.149	.149
AH	1.360	1.400		1.375	1.375	1.375	1.375	1.375
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.215	1.215	1.215	1.215	1.215
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: cmf Date: 11/03/02

Audited by: ml Date: 11/3/02

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46698
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.997	2.997	2.997	2.997	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.130	.130	.130	.130	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.138	.138	.138	.141	.138
AG	0.140	0.160		.149	.150	.150	.149	.149
AH	1.360	1.400		1.370	1.370	1.370	1.370	1.371
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.210	1.210	1.210	1.212	1.212
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>[Signature]</i>	Date: 11/13/12
Audited by: <i>[Signature]</i>	Date: 11/13/12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	46698
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.998	2.998	2.999	2.999	2.999
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.130	.130	.130	.131	.130
AD	0.040	0.060		.057	.050	.050	.049	.050
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.150	.150	.152	.150	.147
AH	1.360	1.400		1.372	1.371	1.372	1.376	1.371
AI	0.040	0.060		.050	.050	.048	.049	.045
AJ	1.190	1.230		1.213	1.210	1.211	1.215	1.212
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	11/03/03
Audited by:	<i>[Signature]</i>	Date:	11-3-04
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	66698
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

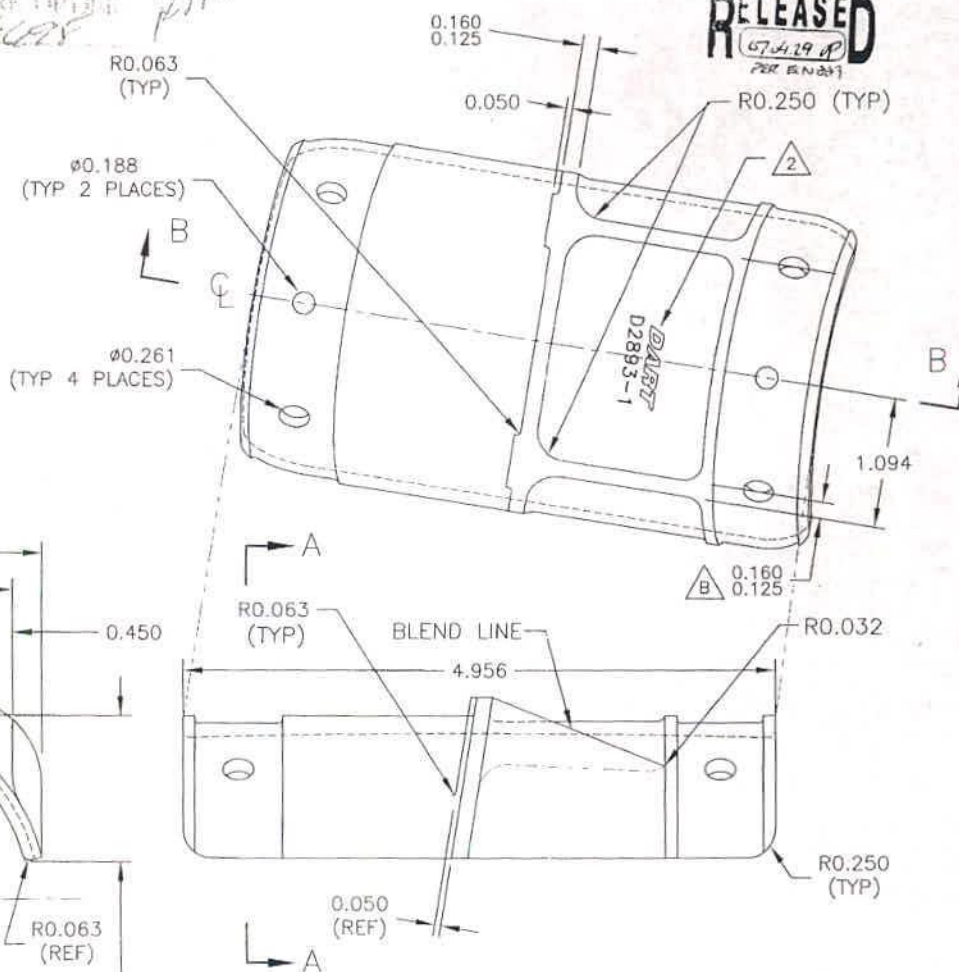
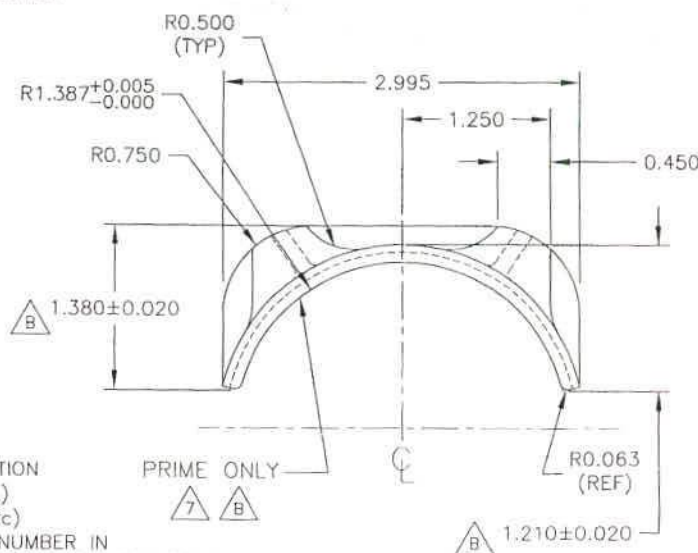
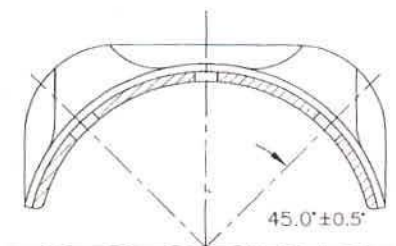
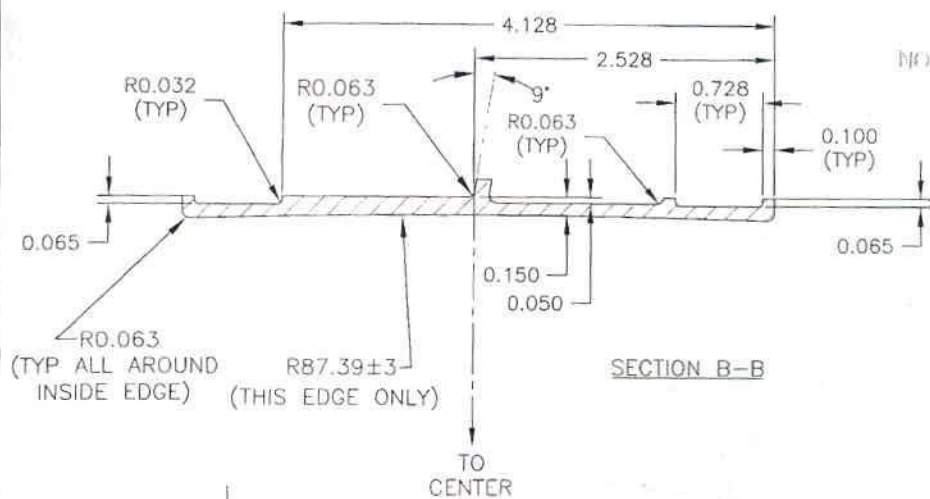
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	217	318	419	520
HAAS Section								
AA	2.985	3.005	Vein M-L-7	2.999	2.999	2.998	2.998	2.998
AB	0.440	0.460	"	.440	.440	.440	.440	.440
AC	0.125	0.160	"	.130	.132	.130	.130	.130
AD	0.040	0.060	"	.050	.049	.050	.050	.050
AE	0.188	0.193	"	.191	.191	.191	.191	.191
AF	0.125	0.160	"	.141	.139	.140	.140	.141
AG	0.140	0.160	"	.150	.152	.150	.151	.153
AH	1.360	1.400	High-veg 31006	1.376	1.376	1.374	1.371	1.373
AI	0.040	0.060	Test-indicator	.048	.048	.049	.049	.046
AJ	1.190	1.230	High-veg 31006	1.213	1.215	1.213	1.211	1.212
AK	0.010	0.020	Test-indicator	.010	.010	.010	.010	.010
AL	0.053	0.073	Red-gage	.063	.063	.063	.063	.063
AM	0.240	0.260	"	.250	.250	.250	.250	.250
AN	2.518	2.538	Vein M-L-7	2.528	2.525	2.528	2.528	2.528
AO	84.39	90.39	"	87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266	Vein M-L-7	.262	.262	.262	.262	.262
AQ	0.053	0.073	Red-gage	.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>and</i>	Date:	11/03/03
Audited by:	<i>and</i>	Date:	11-3-4
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	9P	DRAWN BY
CHECKED	TH	APPROVED
DATE	07.03.16	
DART	DART AEROSPACE LTD.	REV. B
DART	DART AEROSPACE LTD.	SHEET 1 OF 1
DART	DART AEROSPACE LTD.	SCALE
DART	DART AEROSPACE LTD.	1:1